

Date: Wednesday, 10/11/2006 11:12:10 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE SPACER		
Job Number	: 28921		Part Number	: D2935		
Estimate Number	: 11063		Drawing Number	: D2935 REV B		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 10/11/2006 S.O. No. : N/A		Drawing Revision	: B		
Prsht Rev.	: NC		Material	: P/M		
First Issue	: N/A		Due Date	: 10/27/2006 Qty: 40 Um: Each		
Previous Run	: 28265					
Written By	:					
Checked & Approved By	:					
Comment	: Est A 00.06.06 New Issue EO					
	: Est Rev:B Now 6061-T6 06-06-23 JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S080	6061-T6 .080 Sheet
Comment: Qty.: 0.0532 sf(s)/Unit Total : 2.1294 sf(s) Material: M6061-T6 0.080" Thick Batch <u>M101178</u> <u>M 08 10 12</u>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D2935 Dwg Rev: <u>B</u> <span style="margin-left: 100px;"><u>M 08 10 12</u></span> Prog Rev: <u>B</u> <span style="margin-left: 100px;">(40)</span>		
2-Deburr if necessary <u>370 06 10 12 40</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <span style="margin-left: 100px;">(40)</span>		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <u>08 10 12 (610) counted.</u>		
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 <u>06/10/13</u> <span style="margin-left: 100px;">(40)</span>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA: LD Date: 06/10/16  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE SPACER

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Part Number: D2935

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



x40

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ml 06/10/13

7.0 PACKAGING 1

PACKAGING RESOURCE #1



x40

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 395

ml 06/10/13

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

ml 06.10.13

Job Completion



ml 06.10.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	28921
Description: Saddle Spacer	Part Number:	D2935
Inspection Dwg: D2935	Rev: B	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Mr. M.

**Audited by:**

### Prototype Approval:

NA

Date: 06/10/17

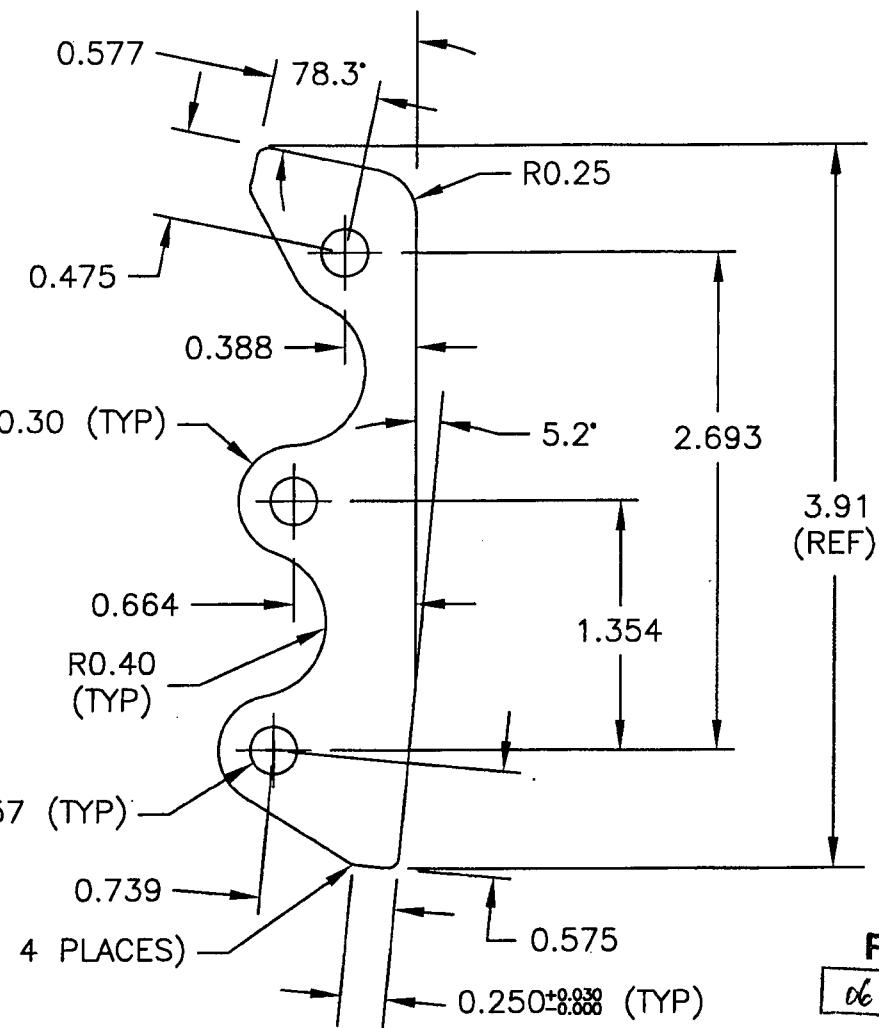
Date: 10/2/12

Date: N/A

Rev	Date	Change	Revised by	Approved
A	06.06.05	New Issue	KJ/JLM	
B	06.06.23	Dwg Rev. changed	KJ/JLM	<i>[Signature]</i>

**DART**

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D2935
DATE		TITLE SADDLE SPACER
06.05.29		SCALE 1:1
A	99.11.02	NEW ISSUE
B	06.05.29	ADD 6061-T6 MATERIAL

**NOTES:**

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" ~~OPTIONAL~~  
(REF DART SPEC M6061T6S.080)  
OR  
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" ~~OPTIONAL~~  
(REF DART SPEC M5052H32S.080)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

*SHIPPING  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 28921*

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